

Work Order ID 51717

August 28, 2009 9:09:34 AM

Page 1

Item ID: D3785-1

Accept

Setup Start

Revision ID: C

Stop

Item Name: Bracket

Start Date: 8/31/09

Start Qty: 6.00

Cust Item ID:

Required Date: 9/04/09

Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3785

Rev C

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3785

Dwg Rev: E

Prog Rev: E

grain along 10.669

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

MAT NOT IN SYSTEM

IB 9-8-31

IB 9-8-31

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

⇒ 502/08/31

0.00

(46)

4

QC

Memo

Quality Control

130

0.00

SB 09/09/07

0.00

(6)

0

Brake NC

Memo

Brake NC

1- bend per dwg

140

QC5- Inspect part completeness to step on W/O

0.00

⇒ 502/02/08

0.00

(46)

4

QC

Memo

Quality Control

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Accept



Setup Start



Revision ID: C

Stop



Item Name: Bracket

Start Date: 8/31/09 Start Qty: 6.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

MD 09/09/08



Memo

0.00

Hand Finishing

160



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

DL 09-09-9



Memo

0.00

Start Time: 11:30

Oven Temperature: 320°

Finish Time: 12:00

11/09/09

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

CL 09/09/09 (6)

Work Order ID 51717

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Page 4

Item ID: D3785-1

Accept

Revision ID: C

Item Name: Bracket

Start Date: 8/31/09

Start Qty: 6.00

Required Date: 9/04/09

Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Identify as per dwg & Stock Location: *ST130*

0.00



Packaging

Memo

*SHIP TO AEROTEX
FOR W/O 51715*

0.00

Packaging

CL 09/09/09 04

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/09/11 [Signature]
MF 09-09-10*

Picklist Print

August 28, 2009 9:09:33 AM

Page 1

Work Order ID: 51717

Parent Item: D3785-1RevC

Parent Item Name: Bracket

Comments:

Start Date: 8/31/09

Required Date: 9/04/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	270.4990	3.4105			



6061-T6 .080 Sheet



13 9-8-31

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	270.499	
107904	0.02	
110254	2.5	
110630	42.9353	
112040	0.0437	
112141	33	
112512	192	

112512

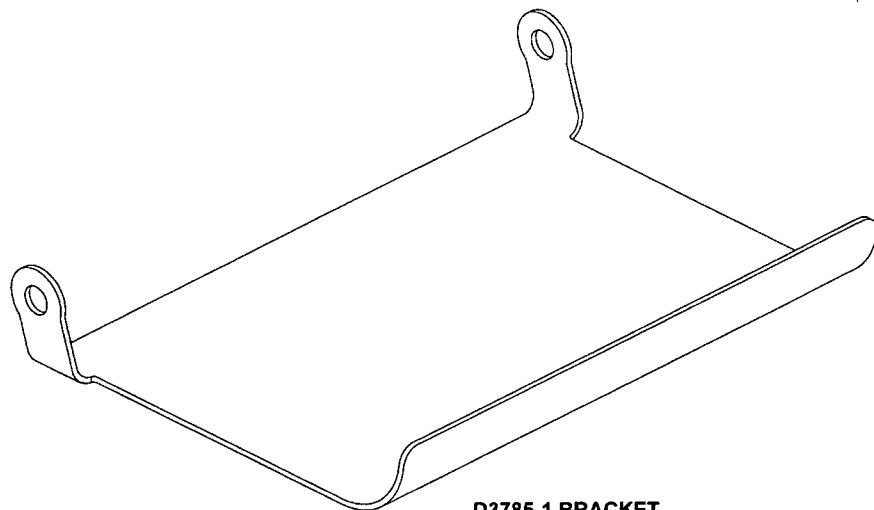
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

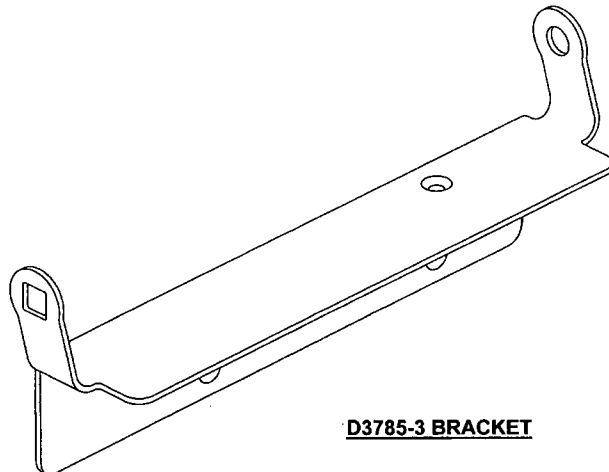
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3785-1 BRACKET



D3785-3 BRACKET

#51717
ME
09-08-31

RELEASED
07/27/14

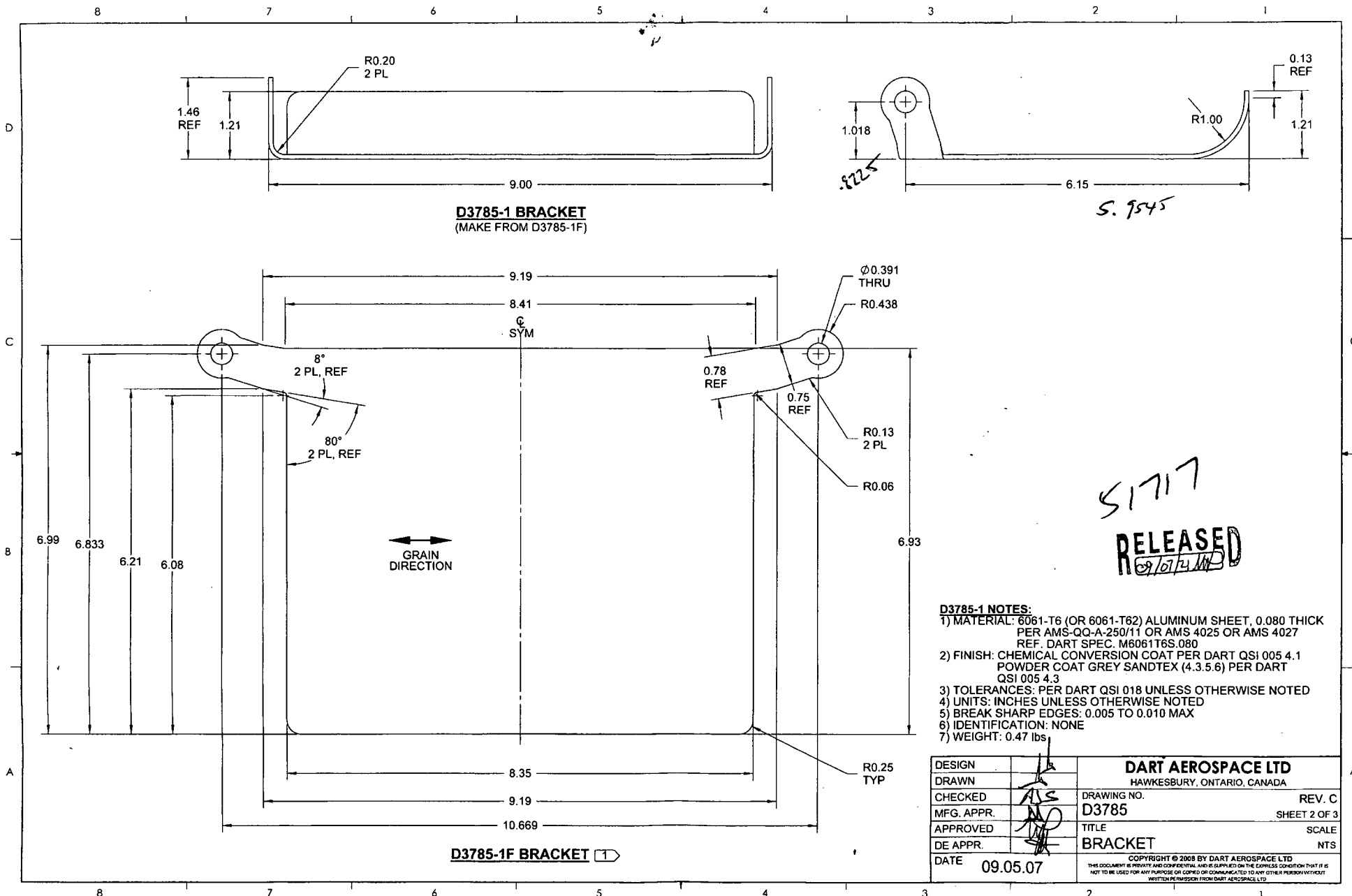
C	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.07
B	REDESIGNED D3785-3; REMOVED P/Ns D3785-041/-1/-5/-7; DRAWING TITLE WAS ARMREST WELDMENT REASON: ELIMINATED ARMREST FWD-AFT ADJUSTMENT; PARTS AND WELDMENT NO LONGER REQUIRED	MB	08.07.18
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3785** REV. C
SHEET 1 OF 3

TITLE **BRACKET** SCALE
NTS

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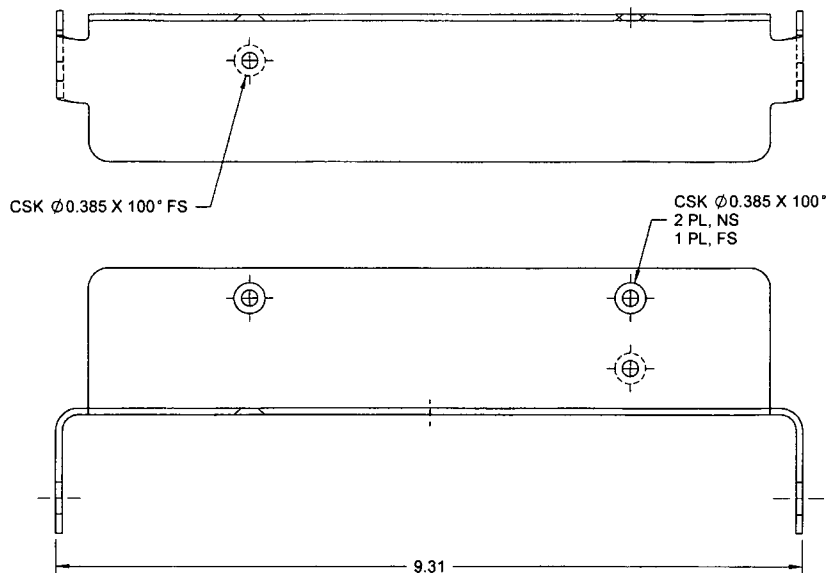


D3785-1 BRACKET
(MAKE FROM D3785-1F)

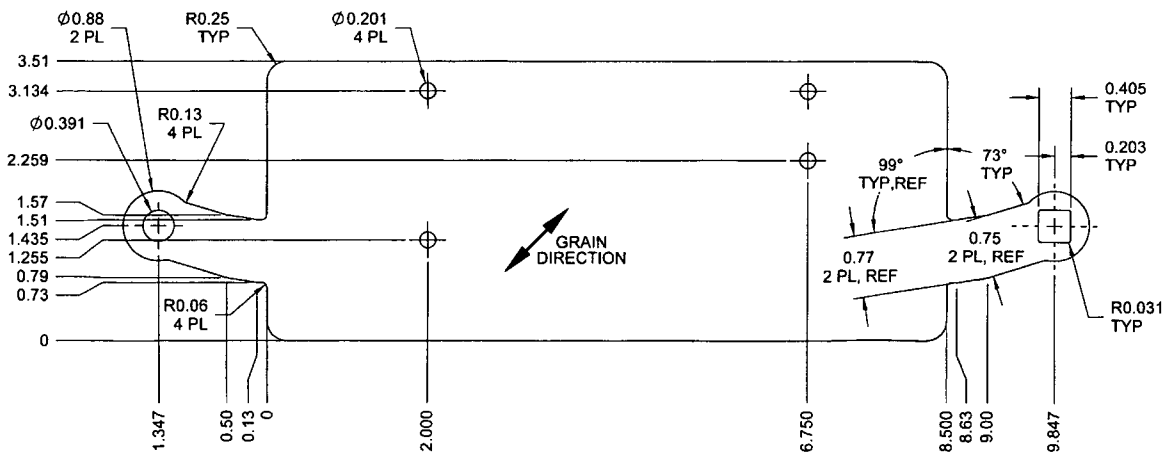
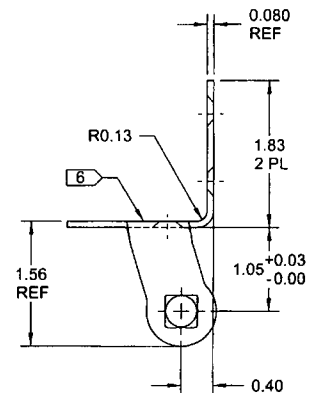
D3785-1F BRACKET 1

- D3785-1 NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF. DART SPEC. M6061T6S.080
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.47 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D3785	SHEET 2 OF 3
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D3785-3 BRACKET
MAKE FROM D3785-3F



D3785-3F FLAT PATTERN 1

51717

RELEASED
09/07/07

D3785-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3785-3" USING FINE
POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

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